



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3490-1**Job Sheet 189837****Part No:** D3490-1**Job Qty:** 40 pcs**Part Name:** Cross Bolt Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/31/19**Job Tracking No:****Due Date:** 2/15/19**Created By:** Jesse White**Type:** Stock**Description:****Note:** DWG REV A IPP Rev:A New Issue 06-03-03 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	40 pcs	2/15/19	2/15/19	0.00	0.00	Hardinge - 1		JBD 1/13/10
120	QC 8	40 pcs	2/15/19	2/15/19	0.00	0.00	QC 8 - 12		m/19/03/12
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
130	Packaging 3-1 - Stock - B4B	40 pcs	2/15/19	2/15/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		

Plex 1/31/19 8:18 AM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				140 QC 21 - SA	40 pcs
				2/15/19	0.00 0.00
				QC 21 - SA - 21	
				QC 21 - SA - 70	

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Part Op 100 - Hardinge - 1-TURN AS PER FOLIO FA628 & DWG D3490

Descriptions: 120 - QC8- Inspect parts - second check

130 - Identify as per dwg & Stock Location: LG001 - CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER

140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.049	6061-T6 Round Tube .500 X.049W	10.6400 ft (.266 ea)	100-Hardinge - 1	<u>2065705</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.500W.049	11	42	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	0.500inches + 0.006 - 0.001	0.506 0.499		
2	Crossbolt Spacer	0.049inches ± 0.010	0.059 0.039		
3	Crossbolt Spacer	0.402inches + 0.006 - 0.001	0.408 0.401		
4	Crossbolt Spacer	3.085inches + 0.030 - 0.000	3.115 3.085		
5	Crossbolt Spacer	0.050inches ± 0.010	0.060 0.040		
6	Crossbolt Spacer	45Degrees ± 0	45 45		

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Date :	Sequen	MRB (QSI042)			
Description Work Order		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Container No: S160920 Part: D3490 - 1 Job No: 189837 Serial No/Batch: S160920 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's		Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Broken/Damaged/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
Other/Details:		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			

Dart Aerospace Ltd.
1270 Aberdeen Street
Newbury, ON K6A 1K7
CANADA
TEL: 513 632-5200
FAX: 513 632-5201
Email: sales@dartero.com
www.dartaerospace.com



Container No: S160920



Part: D3490 - 1

Job No: 189837

Serial No/Batch: S160920

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 03/10/19